

Work Order ID 109624

November-27-13 7:30:24 AM

D 3531-041

B 109624

109624

Page 1

Item ID: D3531-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Top Mounted Gps Bracket
 Start Date: 11/21/13 Start Qty: 7.00 *7* Cust Item ID:
 Required Date: 11/21/13 Req'd Qty: 7.00 *7* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 11-11-22 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|----|
| D3531 | B' |
|-------|----|

| | | | | | | | | | |
|-------|-----------|--|--|--|--|--|--|--|--|
| 100 | Small Fab | 0.00 | | | | | | | |
| *100* | Small Fab | Memo | | | | | | | |
| | Small Fab | Transfer drill holes and assemble as per dwg D3531 | | | | | | | |

| | | | | | | | | | |
|-------|---|------|--|--|--|--|--|--|--|
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *110* | QC | Memo | | | | | | | |
| | Quality Control | | | | | | | | |

| | | | | | | | | | |
|-------|--|------|--|--|--|--|--|--|--|
| 120 | Black Sandtex(Ref 4.3.5.7)per QSI005 4.3 | 0.00 | | | | | | | |
| *120* | Powdercoat | Memo | | | | | | | |
| | Powder Coating | | | | | | | | |

START TIME: 3:00 FINISH TIME: 4:05 OVEN TEMPERATURE: 425

DAS
36
9-89

DAS
34
9-89

1000000

Work Order ID 109624

November-27-13 7:30:24 AM

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Page 2

Item ID: D3531-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Mounted Gps Bracket
 Start Date: 11/21/13 Start Qty: 7.00 ***7*** Cust Item ID:
 Required Date: 11/21/13 Req'd Qty: 7.00 ***7*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|--|--------------------------------------|--|--|--|--|---|--|--|--|
| 130 *130* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 DAS 27 9-89 0.00 13/11/28 | | | | 7 | | | |
|--|--------------------------------------|--|--|--|--|---|--|--|--|

| | | | | | | | | | |
|---|---|--------------|--|--|--|--------------|--|--|-------------------|
| 140 *140* Packaging Packaging | Identify as per dwg & Stock Location: _____ Memo 57228 | 0.00 0.00 | | | | 13/11/28 (7) | | | DAS 32 9-89 |
|---|---|--------------|--|--|--|--------------|--|--|-------------------|

| | | | | | | | | | |
|--|---|--------------|--|--|--|----------|--|--|--|
| 150 *150* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | 13/11/28 | | | |
|--|---|--------------|--|--|--|----------|--|--|--|

Handwritten signatures and dates:
 13/11/28
 MF
 13-11-28

Picklist Print

November-27-13 7:30:28 AM

Page 1/2

Work Order ID: 109624

109624

Parent Item: D3531-041

D3531-041

Parent Item Name: Top Mounted Gps Bracket

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified DD
12.10.24 PER DWG REV.B DD VERF:JLM

IPP REV:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|-------------------|
| D3531-1 *D3531-1* Bracket | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 7 | | 13/11/27 | DAS 36 9-89 |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| GA | 11 | |
| 109303 | 7 | |
| 109364 | 2 | |
| 96115 | 2 | |

D3531-3
Bracket Front Plate

Manufactured No 100 Each 4.0000 1 7

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| GA | 4 | |
| 104587 | 3 | |
| 83014 | 1 | |

MS20426AD4-4

Purchased No 100 Each 5,121.000 2 14

MS20426AD4-4
Rivet

**

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST506 | 5121 | |
| 125445 | 5121 | |

M121090
14x

Picklist Print

November-27-13 7:30:28 AM

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Work Order ID: 109624

109624

Parent Item: D3531-041

D3531-041

Parent Item Name: Top Mounted Gps Bracket

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 7.00

Required Qty: 7.00

MS20470AD4-4

Purchased

No

100

Each

2,644.000

10

70

MS20470AD4-4

Rivet, Universal Head

**

13/11/27

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

1

121652

1

ST336

2643

116188

68

118614

135

122027

188

m125807

78

m126275

2174

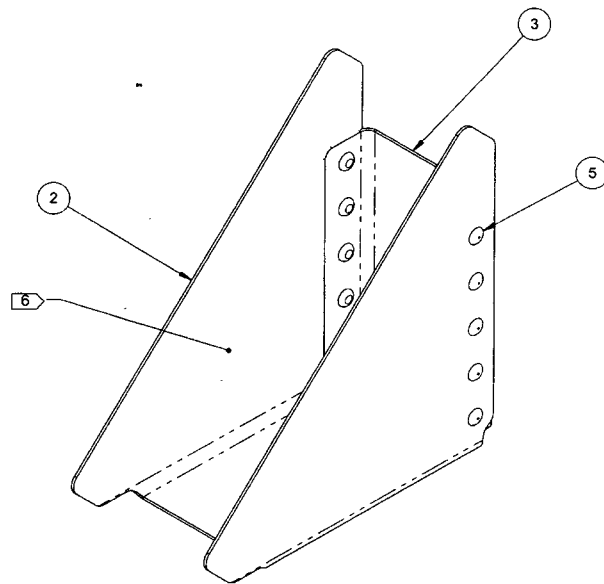
70

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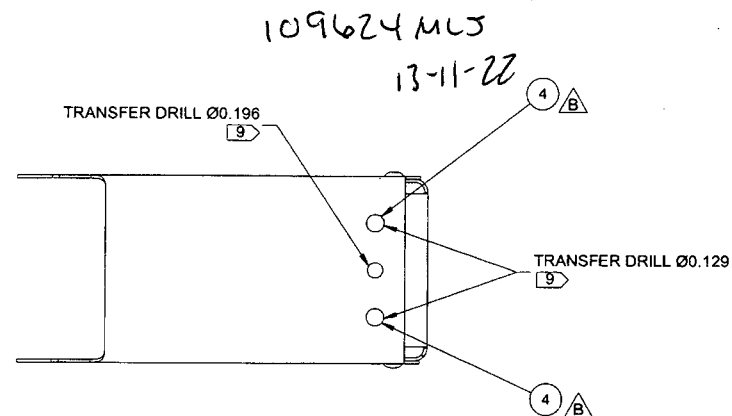
Shop Packet Print

Page 2

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|--------------|---------------------|
| 1 | X | D3531-041 | BRACKET ASSEMBLY |
| 2 | 1 | D3531-1 | BRACKET |
| 3 | 1 | D3531-3 | BRACKET FRONT PLATE |
| 4 | 2 | MS20426AD4-4 | RIVET |
| 5 | 10 | MS20470AD4-4 | RIVET |



D3531-041 BRACKET ASSEMBLY

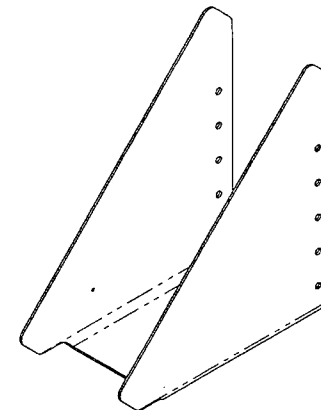
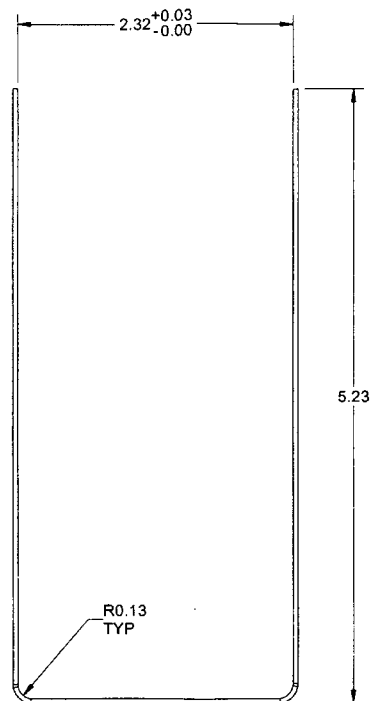


**D3531-041 BRACKET ASSEMBLY
BOTTOM VIEW**

RELEASED
12/19/23 9'
PER EN 12-669

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT ASSEMBLY "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
 - 7) WEIGHT: 0.22 lbs
 - 8) ASSEMBLE PER DART QSI 003
 - 9) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

| | | | |
|------------|--|--|--------------|
| B | CHANGE BOTTOM RIVETS FROM MS20470AD4-4 TO MS20426AD4-4, ZN C2-1, C5-3. ADD CSK, ZN C5-3. CORRECT BEND LINE DIM, ZN C4-3. UPDATE TO CURRENT DWG STANDARDS, REF PAR 10-47. | DC | 12.08.09 |
| A | NEW ISSUE | CB | 07.06.19 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | BC | | |
| CHECKED | BE | DRAWING NO. | REV. B |
| MFG. APPR. | AV | D3531 | SHEET 1 OF 5 |
| APPROVED | AP | TITLE | SCALE |
| DE APPR. | CH | BRACKET ASSEMBLY | NTS |
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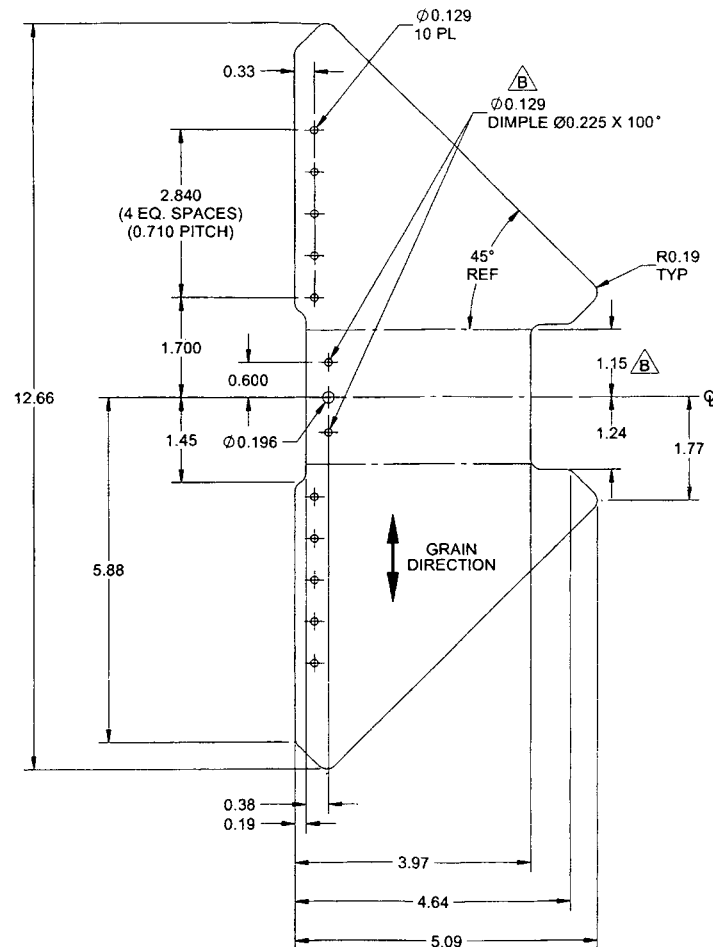


D3531-1 BRACKET

RELEASED
12/10/15

- NOTES:**
- 1) MATERIAL: MADE FROM D3531-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | BC | | |
| CHECKED | AE | DRAWING NO. | REV. B |
| MFG. APPR. | AV | D3531 | SHEET 2 OF 5 |
| APPROVED | MP | TITLE | SCALE |
| DE APPR. | HA | BRACKET ASSEMBLY | NTS |
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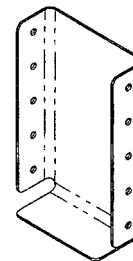
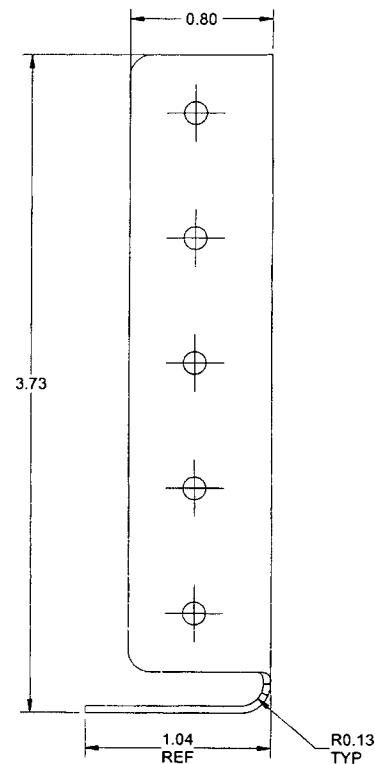
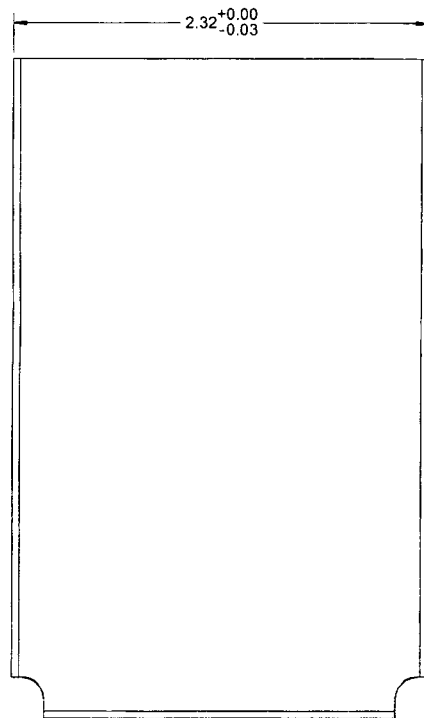
D3531-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.16 lbs

RELEASED
12/19/23

| | | | |
|--|----------|--|--------------|
| DESIGN | CB | DART AEROSPACE LTD | |
| DRAWN | BC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | BC | DRAWING NO. | REV. B |
| MFG. APPR. | BC | D3531 | SHEET 3 OF 5 |
| APPROVED | BC | TITLE | SCALE |
| DE APPR. | BC | BRACKET ASSEMBLY | NTS |
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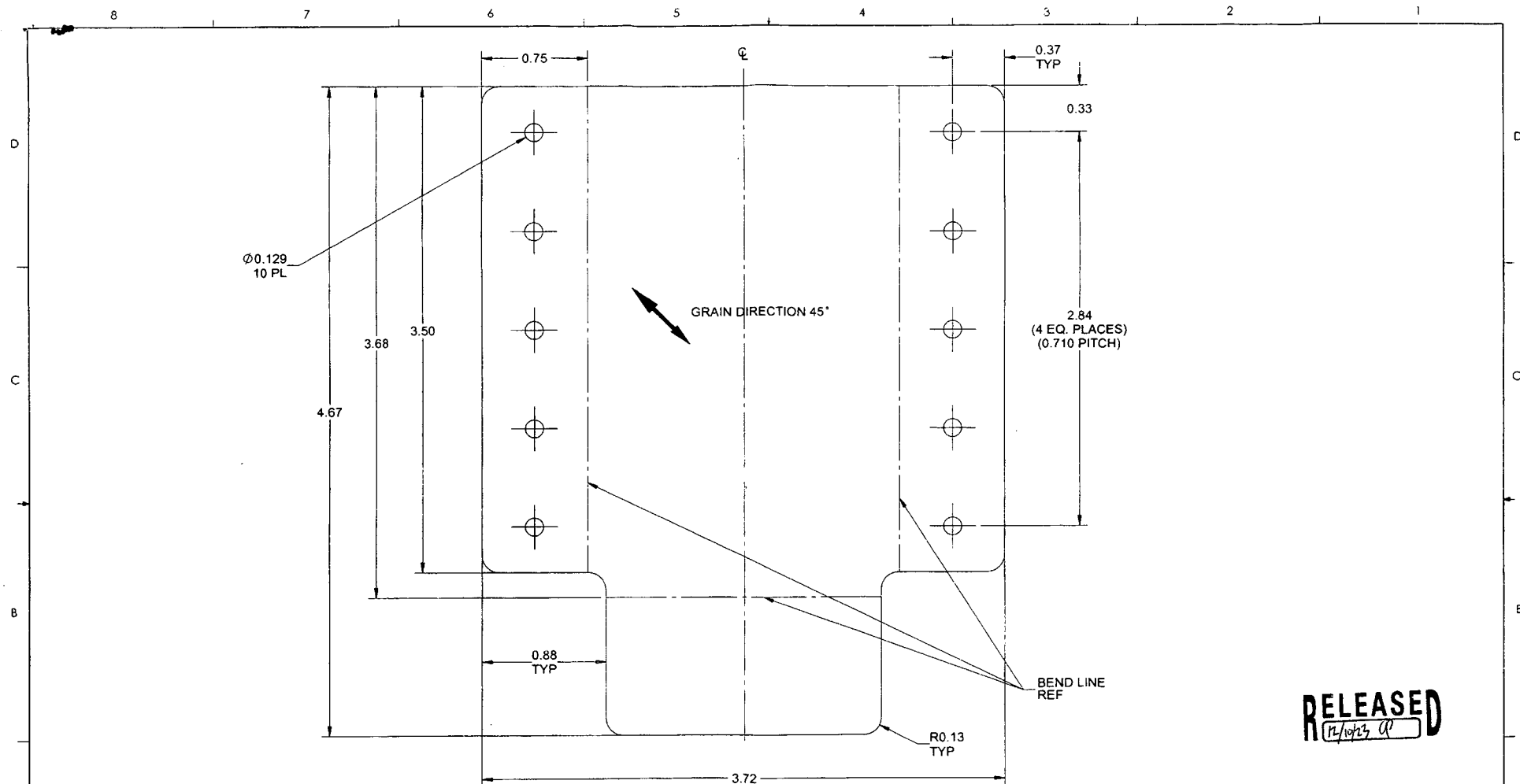
D3531-3 BRACKET FRONT PLATE

NOTES:

- 1) MATERIAL: MADE FROM D3531-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

| | | | |
|------------|----------|--|--------|
| DESIGN | CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | BC | | |
| CHECKED | BE | DRAWING NO. D3531 | REV. B |
| MFG. APPR. | AV | SHEET 4 OF 5 | |
| APPROVED | AD | TITLE | SCALE |
| DE APPR. | AD | BRACKET ASSEMBLY | NTS |
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RELEASED
12/10/13 QP



D3531-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

| | | | |
|--|----------|--|--------------|
| DESIGN | C.B. | DART AEROSPACE LTD | |
| DRAWN | JFC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | BE | DRAWING NO. | REV. B |
| MFG. APPR. | AV | D3531 | SHEET 5 OF 5 |
| APPROVED | MA | TITLE | SCALE |
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